Work Orde		6309		*106			•	, '	Page 1		
tem ID: Revision ID:	D4032-041			Accept	*N900	040	100)* s	etup Star	t *N	S1*
tem Name:	Short Basket	Assembly (350)	6						Stop	*N	S2*
tart Date: Required Date: Reference:	8/28/13 8/28/13	Start Qty: 300 Req'd Qty: 300	,		Cust Item l Customer:						, , .
approvals:	Process Pla	an: ML5	Date: \(\frac{13-08-}{}	70 Tooling:	. D	ate:	_	R	tun Star	^t *N	R1*
трргочаіз.		an. <u>P1CS</u>	Date:			ate:			Stop)	R2*
equence ID/ Vork Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D4032	E										
00		Pick Kit		0.00							DA:
100 Packaging Packaging		Memo		0.00					13/3/.	23 (32
10		Assemble as per dwg		0.00						00	,
11 0									\$ 1	K13-	4.24
HandFinish			k label plate to size of D408 i for label, apply label ****	0.00 6 label, use scotchbrite re	d pad to lightly			·			
20	-	QC5- Inspect part cor	npleteness to step on W/O	0.00	DAS)			
120 QC Quality Control		Memo		0.00	27 9-89			<u> </u>			
	•	•	(1		129,24					,	

DQA: Date	e:
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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									_		QA Closed:	Dat	te:		
Work Orde	er:	~				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N					Rework Scrap Use-as-is		ſ	Skid-tube Machining	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Quality			
NCR N	NCR No Work Order Update								Large Fab						
Root					Descri	ption of work order update	Initi	al	Ad	ction	Sign &				
Cause		Date	Step	Qty	·	or Non-conformance	Chief	Eng	Desc	cription	Date	Verification	n QC Inspector		
Doc/Data												:			
Equip/Tooling									:						
Operator	-														
Material															
Setup				٠.											
Other	·						l					•			
Process															
Supplier															
Training															
Unapproved			<u> </u>												
						F	AULT C	ATE	GORY						
Landi	ng G	ear				General	_				7				
	\vdash	Bending				Bend	Gra	ain		<u> </u>	Ovalized		Pressure/Forced		
	\vdash	Centre No	ot Concer	ntric to	o/s	BOM/Route	Har	rdwa	re	_	Over/Under	tolerance	Temperature/Cure		
	-	Cracks				Broken/Damaged	\mathbf{H}		on Incomplete	L	Part Incorre	1	Weld		
	-	Crushed/0	Crimped			Burrs	——		ions Incomplete,	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled		
		Cuffs				Contamination			nance		Part Moved				
:	Ш	Heat Trea				Countersink	Mis	slabe	led	<u> </u>	Positioned V		·		
	$\boldsymbol{\vdash}$	Inspection	-	Tube		Cut Too Short	—	read	I	<u></u>	Power Loss/	Surge	Other		
	Ripples in Bend Drill Holes					Off									
	Torque Waves in Extrusion Drawing					\blacksquare		Calibration							
	Turning Sequence Finish					-1	Out	t of S	equence						
	Waye/Twist in Tube						Library	Outside Dimensions							

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140

Packaging

Packaging

QC21- Final Inspection - Work Order Release

0.00

0.00

140

QC Quality Control

Memo

Memo

0.00

-1-24 ... MF: 3

Insp.

Page 2

DQA:	Date:	
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WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Engineering Skid-tube Crosstube Water Jet Rework Small Fab Prod. Eng. Coor. Quality Part No. Machining Scrap Thermoforming Finishing Rec/Store/Packaging Use-as-is Other NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Initial Action Sign & Root Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Ovalized Pressure/Forced Bending Grain Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Part Incorrect Weld Cracks Inspection Incomplete Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Maintenance Contamination Part Moved Mislabeled Heat Treat Countersink Positioned Wrong Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge **Drill Holes** Offset Ripples in Bend **Torque Waves in Extrusion** Drawing **Out of Calibration Turning Sequence** Finish Out of Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

Work Order ID: 106309

*106309

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

106309 *D4032-041*

Start Date: 8/28/13

Required Date: 8/28/13

Start Qty: 2:00 /

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 09.12.02 verified by:EC

IPP Rev:B as

per PA3 DD 10.03.10 verified by:EC

IPP Rev:C as per RevA DD IPP Rev:D as per dwg revC DD 10.04.20

10.03.23 verified by:EC verified by:EC

IPP Rev:E as per dwg revD DD 10.08.18 verified

by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530		Manufactured	No			100	Each	15.0000	1	~		***************************************	QAg.
D2530 Handle Weldment									**		34 c	7	≎An 32 •••••
				Location	•	Loc	<u>Oty</u>	Loc Code					
				ST255			15		_		-		
					103407		3		_		_		
					105285		5		_		_		
					92130		2						
	•				98072		5		-				_
D2535		Manufactured	No			100	Each	152.0000	2	a (DAG.
D2535									**			***************************************	32
Spring				Location	Į.	<u>Loc</u>	<u>Otv</u>	Loc Code				13	14/23(1)
				ST011		•	152		_		_	, ,	
					100552		98		_		-,		
					102576		50		-4	/sa57	6		
					96248		4		_		•••		

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-O	O	NFOR	MANCE / UPDATE		QA Closed:	Date:	
				****	DISPOSITION			ACAING		PARTMENT		
Work Orde	er:				DISPOSITION	_		AGAIN.		- -		_
Part N	lo				Rework Scrap Use-as-is		1	Skid-tube Crosstub Machining Small Fa noforming Finishir	ıb 🗀	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo			· · · · · · · · · · · · · · · · · · ·	Work Order Update]		Large Fab Composit	_	Nec/stor	Supplier	J Other
Root				Descri	ption of work order update	Ī	Initial	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling			İ									
Operator												
Material		Į										
Setup												
Other								,				
Process												
Supplier				:								
Training				1								
Unapproved		<u> </u>										
					F	AUL	T CATE	GORY				
Landir	ng Gear				General					-		-
	Bending				Bend	L	Grain			Ovalized		Pressure/Forced
	Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	t	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
1	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	at		[Countersink		Mislabe	led		Positioned W	/rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 106309 Parent Item: D4032-041 Parent Item Name: Short Basket	Assembly (350))6309* 4032-041*				art Date: {	2/20/12	Required Date: 8/28/13
Parent Item Name: Short Basket	Assembly (330)						art Date: 0 tart Qty: 2		Required Qty: 2.00
*D2537	Manufactured	No		100	Each	148.0000	2 **	3	Ç ^A ⁄3 32 3€
Bushing									
			Location	Le	oc Oty	Loc Code			
			ST008		44				
			102982		30			99011	
			99011		14			17011	
			ST011		104 38				
			100454 103608		38 24				
			103861		40				
			98426		2				_
03917-3	Manufactured	No		100	Each	247.0000	6	× 12	CAS .
D3917-3							**		
			<u>Location</u>	<u>L</u>	oc Qty	Loc Code			
			ST072		247			1 , 2 9 9	•
			100397		82			1003/1	
			102913		4				
			103536		41 120				
03953-3	Mr. Coston d	No	104859	100	Each	47.0000	2	4	
	Manufactured	NU		100	Lacii	47.0000		20	
D3953-3							**		
ias Spring Stud, Lid		•	<u>Location</u>	L	oc Qty	Loc Code			13/5/
			GA		1				
	.* .*		87592		1				
		:	ST076		46				
		* .	102196		32			102/96	
			88494		14				

										DQA:	Date:	
NCR: Y	es / No	,			WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE	OA Classide	Data	
							r			QA Closed:	Date:	
Work Orde	sr.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	···				Rework	1	Skid-tube Crosstube			1	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining Small Fab			d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing	4	re/Packaging	Other
NCR N	lo				Work Order Update]		Large Fab	Composite]	Supplier	
Root		Ī	<u> </u>	Descri	ption of work order update	Γ	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data		,										
Equip/Tooling												
Operator												
Material										ļ		
Setup												
Other						1						
Process ⁻						1						
Supplier												
Training												
Unapproved			<u> </u>									
						AUL	T CATE	GORY		•		
Landir	ng Gear			_	General	_	7		_	7	_	1
	Bending			<u> </u>	Bend	L	Grain		}	Ovalized		Pressure/Forced
		ot Conce	ntric to	o/s	BOM/Route	_	Hardwa		<u> </u>	Over/Under		Temperature/Cure
ļ	Cracks				Broken/Damaged	L	1 '	on Incomplete		Part Incorred	<u> </u>	Weld
	_	/Crimped		<u> </u>	Burrs		1	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	•		Part Moved		
	Heat Tre	at		<u> </u>	Countersink	<u></u>	Mislabe	led	<u> </u>	Positioned V	_	1
	Inspection	n Strip in	Tube		Cut Too Short Misread					Power Loss/	Surge	Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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106309 Work Order ID: 106309 Parent Item: D4032-041 *D4032-041* Parent Item Name: Short Basket Assembly (350) **Start Date: 8/28/13** Required Date: 8/28/13 Start Qty: 2.00 Required Qty: 2.00 96.0000 100 D3953-7 Manufactured Each ** *D3953-7* Spring Spacer Loc Code Location Loc Oty 96 ST076 100414 26 102928 24 105465 45 99148 100 80.0000 Each D3953-9 Manufactured ** GAS SPRING WASHER Loc Code Location Loc Qty ST076 80 23 102166 103615 46 94719 4 95127 7 26.0000 D3953-17 Manufactured 100 Each Gas Spring Spacer Location Loc Qty Loc Code 26 ST075 26 100353 17.0000 D3953-19 No 100 Each Manufactured Gas Spring Bracket Loc Oty Loc Code Location ST077 17 17 100341

DQA:	Date:		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	,								QA Closed:	Date	•
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo			_	Rework Skid-tube Crosstube Machining Small Fab Use-as-is Thermoforming Finishing Composite					Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initia	A	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
1	<u>_</u>	<u>. </u>	11		F	AULT CA	TEGORY		1		
Landir	ng Gear				General						
	Bending Centre No	ot Concer	ntric to C	o/s	Bend BOM/Route	Grai Hard	ware		Ovalized Over/Under		Pressure/Forced Temperature/Cure
	Cracks Crushed/ Cuffs Heat Trea	·			Broken/Damaged Burrs Contamination Countersink	Instr	ection Incomplete uctions Incomplete ntenance abeled	/Unclear	Part Incorred Part Lost/Mi Part Moved Positioned V	issing	Weld Wrong Stock Pulled
·	Inspection		Tube		Cut Too Short	Misr			Power Loss/		Other
Ì	Ripples in				Drill Holes	Offse	t	<u> </u>		· ·	
	Torque W	aves in E	xtrusion		Drawing	Out	of Calibration				
	Turning S				Finish	Out	of Sequence				
	Wave/Tw	ist in Tub	oe .		Folio	Outs	ide Dimensions				

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106309 Work Order ID: 106309 Parent Item: D4032-041 *D4032-041* Parent Item Name: Short Basket Assembly (350) **Start Date: 8/28/13** Required Date: 8/28/13 Start Qty: 2:00 Required Qty: 2.00 17.0000 D3953-21 100 Each Manufactured ** *D3953-21* Gas Spring Bracket Location Loc Qty Loc Code ST077 17 . 100404 17 100 55.0000 D3969-3 Each Manufactured *D3969-3* ** Gas Spring Location Loc Qty Loc Code ST262 55 1006// 100611 38 99623 17 D4017-041 100 Each 0.0000 Manufactured No ** *D4017-041* 106089 Short Basket Base Assembly (350) 100 Each 0.0000 D4018-041 Manufactured ** Short Basket Lid Assembly (350) 147.0000 AN3-14A 100 Each Purchased No ** *AN3-14A* Bolt Location Loc Qty Loc Code ST351 46 125749 m125709 46 ST511 100 100 m126192 ST512 123759

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	100	NFORN	MANCE / UPDAT		•		
										QA Closed:	Date	:
Work Orde	ř.				DISPOSITION			A	AGAINST DEF	PARTMENT	PROCESS	
Part N	o				Rework Scrap Use-as-is	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other	
NCR N	o				Work Order Update]		Large Fab Co	mposite		Supplier	ال ال
Root		Ī		Descri	ption of work order update	<u> </u>	Initial	Action		Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Ch	nief Eng	Description	n	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												·
Supplier						ł						
Training						l				!		
Unapproved												<u> </u>
					F	AUL	LT CATE	GORY				
Landin	ig Gear				General	_	-				_	_
L	Bending			`	Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
, l	Cracks			L	Broken/Damaged	L	Inspecti	on Incomplete		Part Incorred	ct _	Weld
*.	Crushed/	Crimped			Burrs		Instructi	ons incomplete/Unclea	ar 📗	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Offset						

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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106309 Work Order ID: 106309 *D4032-041* Parent Item: D4032-041 Required Date: 8/28/13 Parent Item Name: Short Basket Assembly (350) **Start Date: 8/28/13** Required Qty: 2.00 Start Qty: 2.00 171.0000 100 Purchased No Each AN3-16A ** *AN3-16A* Location Loc Qty Loc Code GA 47 117441 47 ST352 124 8 122407 M125952 16 M/2 6/92 M126192 100 100 Each 137.0000 AN4-12 Purchased No ** *AN4-12* Loc Qty Loc Code Location ST356 137 5 124805 m125709 50 M126193 82 m126193 100 Each 434.0000 AN5-17A Purchased No ** *AN5-17A* Bolt Loc Qty Loc Code Location GA 36 36 117872 ST337 4 124215 2 124805 2 st503 244 M126176 244 m126176 ST514 150 125388 150

NCR: Y	es /	No No			WORK ORDER NON-	COI	NFORM	MANCE / UPDAT		QA Closed:	Date:	•
Work Orde	er: _		Marin		 DISPOSITION Rework	1			GAINST DEI			Engineering
Part N	-				Scrap Use-as-is Work Order Update		Therm	Machining Sr noforming F	mall Fab Finishing mposite		d. Eng. Coor. re/Packaging Supplier	Quality Other
Root Cause	:	Date	Step	Qty	ption of work order update		nitial iief Eng	Action Description	n	Sign & -	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						AUL	T CATE	GORY				
Landir	B C C C C C H	ending entre No racks rushed/o uffs leat Trea nspection ipples in	t n Strip in	Tube	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unclea nance led	ar	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	st ssing //	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 106309

Parent Item:

Parent Item Name: Short Basket Assembly (350)

D4032-041

106309

D4032-041

Start Date: 8/28/13

Start Qty: 2:00

Required Date: 8/28/13

Required Qty: 2.00

AN310-4

Purchased

Purchased

No

No

100

Each

110.0000

Loc Code

**

AN310-4

Location Loc Qty 110 ST342 112969 2 2 122800 M125716 50 M125752 6 M126400 50 100 Each

102.0000

Loc Code

**

M122993

AN310C4

AN310C4

Location	Loc Qty
ST342	102
123831	2
126192	50
M125952	50

NCR:	res / N	0			WORK ORDER NON-O	100	NFORI	MANCE / UPI	DATE	•		
								-		QA Closed:	Date	•
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	ł	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	No				Work Order Update]	mem	Large Fab	Composite	Rec/Stor	Supplier	J Other
Root				1	ption of work order update	1	nitial		ion	Sign &		
Cause	Dat	e Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling	Ц											
Operator	\Box											
Material												
Setup												
Other				<u> </u> -								
Process		Ì										
Supplier						l						
Training	H											
Unapproved	LL	L	l	L		<u> </u>	T CATE	CORV				
Landi	ng Gear				General	AUL	.I CAIE	GONT				
Lanui	Bendi	na			Bend		Grain			Ovalized		Pressure/Forced
		e Not Conc	entric to	o/s	BOM/Route	\vdash	Hardwa	ıre	 	Over/Under	tolerance	Temperature/Cure
	Crack			·, -	Broken/Damaged	\vdash	1	ion Incomplete	<u> </u>	Part Incorred	├	Weld
S.	-	ed/Crimped	i		Burrs		1	ions Incomplete/L	Jnclear	Part Lost/Mi	<u> </u>	Wrong Stock Pulled
	Cuffs				Contamination		Mainte			Part Moved		
	Heat	Γreat			Countersink		Mislabe	eled		Positioned V	Vrong	
	Inspe	ction Strip i	n Tube		Cut Too Short		Misread	d		Power Loss/:	_	Other
	—	s in Bend			Drill Holes		Offset		L	•	- L	
i	Torqu	e Waves in	Extrusio	n	Drawing		Out of 0	Calibration				
	Turni	ng Sequenc	e		Finish		Out of 9	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 106309

Parent Item:

D4032-041 Parent Item Name: Short Basket Assembly (350) *106309*

D4032-041

Start Date: 8/28/13

Required Date: 8/28/13

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

100

Each

7,008.000

**

MS21042I3

Location	Loc Oty	Loc Code	
FP001	3		
122141	3		
GA	18		
122452	18		***************************************
ST314	604		
111668	1		
117885	32		<u></u>
119017	55		
119075	138		
123265	43		
M126036	335		
ST506	1383		
123900	912		
124291	471		
ST510a	5000		
M126275	1000		M121, 200

MS21042L5

Purchased

No

4000 100 Each

1,211.000

MS21042L5

Location	<u>n</u>	Loc Qty	Loc Code	
ST314		230		-
	125654	230		
ST506		1		
	123900	· 1		
st507		980		
	125535	980		

M126333

				DQA:	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

		1									QA Closed:	Dat	te:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		nitial	Act	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	1	QC Inspector
Doc/Data														
Equip/Tooling														
Operator	Ш													
Material	Ш													
Setup	Ш													
Other	Ш													
Process	Ш													
Supplier	Ш													
Training	\sqcup		1											
Unapproved	<u> </u>			l										
							AUL	T CATE	GORY					
Landi	$\overline{}$	1				General		la			1	ſ		<i>t</i> = 1
	\vdash	Bending			0/6	Bend	\vdash	Grain		—	Ovalized			ressure/Forced
	\vdash	Centre No	ot Concei	ntric to	^{0/5} -	BOM/Route	-	Hardwa		<u> </u>	Over/Under	ŀ		emperature/Cure
	\vdash	Cracks	C-:		-	Broken/Damaged	-	1	ion Incomplete	Linelana	Part Incorred			Veld
		Crushed/ Cuffs	Crimpea		<u> </u>	Burrs Contamination	\vdash	Mainte	tions Incomplete/	Unclear	Part Lost/Mi Part Moved	ssing [v	rong Stock Pulled
	\vdash	Heat Trea			<u> </u>	Countersink	\vdash	Mislabe		<u> </u>	Positioned V	drong		
	\vdash	Inspectio		Tube	⊢	Cut Too Short	-	Misrea		-	Positioned v		\neg	ther
	\vdash	Ripples in		Tube	-	Drill Holes		Offset	4	L	I OMEL FOSSA	ouige [CHE!
	\vdash	Torque W		extrusio	" ├	Drawing	\vdash	4	Calibration					<u> </u>
	-	Turning S			··	Finish	-	1	Sequence					
		W/2VP/TM			-	Folio	\vdash	1	Dimensions					

August-28-13 11:56:07 AM										
Work Order ID: 106309		*1	0630)9*						
Parent Item: D4032-041				2-041*						
Parent Item Name: Short Basket Ass	sembly (350)		/	<i>></i> -()-+ 1			St	art Date:	8/28/13	Required Date: 8/28/13
							S	tart Qty: 2	2.00	Required Qty: 2.00
MS24665-151	Purchased	No			100	Each	211.0000	3		
MS24665-151	Turonassa							**		(35)
			<u>Locatio</u>	<u>n</u>	Lo	c Oty	Loc Code			
			GA			28				_
				17566		28				_
			ST323			183				_
				122802		20				-
				124859		4			10 =/ /	<u>.</u>
				125646		159			123676	2
MS24665-300	Purchased	No			100	Each	163.0000	2	*	2.2
M\$24665-300								**		(32 , a.g. /
			Locatio	<u>n</u>	Lo	c Qty	Loc Code			
			GA			37			***	_
				118234		37				_
			ST299			126				_
				124555		126			1245	50
NAS1149F0432P	Purchased	No			100	Each	2,376.000	6	12'	
NAS1149F0432	P							**		13/7/23(1)
			Locatio	<u>on</u>	<u>Lo</u>	c Qty	Loc Code			ρA
·		÷	ST295			376			-	. ජූර් -
				122151		2				_
						4				_
										_
							•			- .
				· ·			٠			<u>-</u>
			CTEIA-						-	
			51310a						m12626	\mathcal{M}
NAS1149F0432 WASHER	P			122151 123522 123900 124580 124859 125268	<u>Lo</u>	376· 2	Loc Code	**	m/2 6 26	13/7/2 3 (1)

Picklist Print

Page 8

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	CON	FORM	MANCE / UPDATE		QA Closed:	Date	•
					DISPOSITION			ACAINICT	ה			•
Work Orde	er:				DISPOSITION	.			_	PARTMENT/		
Part N	•				Rework Scrap Use-as-is		I Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing		4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	NO				Work Order Update	J		Large Fab Composite	_	<u> </u>	Supplier	
Root				Descri	ption of work order update	In	nitial	Action		Sign &]
Cause	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Description		Date	Verification	QC Inspector
Doc/Data				1		İ						
Equip/Tooling						l						
Operator												
Material							1					
Setup					-							
Other												
Process												
Supplier												
Training												
Unapproved												
					F.	AULT	CATE	GORY			***	
Landi	ng Gear				General				_	-		_
	Bending				Bend	\square	Grain		L	Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete	L	Part Incorrec	:t	Weld
-	Crushed	/Crimped		L	Burrs	Шı	Instruct	ions Incomplete/Unclear	L	Part Lost/Mis	ssing	Wrong Stock Pulled
•	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Tre	eat			Countersink	[]r	Mislabe	led		Positioned W	/rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print August-28-13 11:56:07 AM				Page 9
Work Order ID: 106309 Parent Item: D4032-041 Parent Item Name: Short Basket Assembly (350)	*106309* *D4032-041*		Start Date: 8/28/13 Start Qty: 2.00	Required Date: 8/28/13 Required Qty: 2.00
NAS1149C0432R Purchased	No	100 Each	7,644.000 2	S. Carlotte and the second
NAS1149C0432R			**	The state of the s
	Location ST292 119124 121255 121825 122441 m125807 ST510a	Loc Oty 2772 6 32 8 77 2657 4872	Loc Code	
NAS1149F0332P Purchased *NAS1149F0332P* Washer	m126221 No	4872	9,540.000 8 16 **	igi
	Location GA 122063 ST294 122063 ST295 123352 st510 123900 ST510a 125646	182 182 158 158 3 3 4197 4197 5000 5000	Loc Code	
*NAS1149F0563P Purchased *NAS1149F0563P* Washer	No	100 Each	610.0000 4	- 13/7/23 (
	Location ST295 121350	<u>Loc Oty</u> 610 610 ∠	Loc Code	20 335

DQA:	Date:	
	•	 _

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

								•		QA Closed:	Date	:
Work Orde	÷.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR No	0			·····	Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	lni	itial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling				,								
Operator						1						
Material	7	:				1	f					
Setup	╗											
Other												
Process												
Supplier												
Training		ļ					ĺ					
Unapproved												
					F	AULT	CATE	GORY				
Landin	g Gear				General					-		
ſ	Bending				Bend	G	irain			Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to	o/s	BOM/Route	Пн	lardwa	re		Over/Under	tolerance	Temperature/Cure
Γ	Cracks				Broken/Damaged	Ir	ıspecti	on Incomplete		Part Incorred	ct	Weld
Γ	Crushed/	Crimped			Burrs	Ir	ıstruct	ions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	\square	/lainte	nance		Part Moved	_	_
	Heat Trea	it			Countersink	\square	/lislabe	eled		Positioned W	Vrong	_
	Inspection	n Strip in	Tube		Cut Too Short	\prod N	/lisreac	t		Power Loss/	Surge	Other
Ī	Ripples in	Bend			Drill Holes	По	ffset		_	_		
	Torque W	aves in E	xtrusio	n 🗀	Drawing	\bigcap o	ut of (Calibration				
Ī	Turning S	equence			Finish	По	ut of S	Sequence				
Ī	Wave/Tw	ist in Tul	ре		Folio	По	utside	Dimensions				

	ITEM	-041 QTY.	P/N	DESCRIPTION
		Х	D4032-041	SHORT BASKET ASSY (350)
	1	1	D2530	HANDLE WELDMENT
		2		
	2		D2535	SPRING
_	3	2	D2537	BUSHING
D	4	6	D3917-3	WASHER
	5	2	D3953-3	GAS SPRING STUD, LID
	6	2	D3953-7	GAS SPRING SPACER
	7	2	D3953-9	GAS SPRING WASHER
	8	2	D3953-17	GAS SPRING SPACER
	9	1	D3953-19	GAS SPRING BRACKET
	10	111	D3953-21	GAS SPRING BRACKET
-	11	1	D3969-3	SPRING
	12	1	D4017-041	SHORT BASKET BASE ASSY (350)
•	13	1	D4018-041	SHORT BASKET LID ASSY (350)
	14	2	AN310C4	NUT, PLAIN, CASTELLATED
	15	3	AN310-4	NUT, PLAIN, CASTELLATED
	16	4	AN3-14A	BOLT
С	17	2	AN3-16A	BOLT
۱۲	18	3	AN4-12	BOLT
	19	4	AN5-17A	BOLT
1	20	6	MS21042L3	NUT, SELF-LOCKING
- 1	21	4	MS21042L5	NUT, SELF-LOCKING
	22	3	MS24665-151	COTTER PIN
Ī	23	2	MS24665-300	COTTER PIN
Ī	24	8	NAS1149F0332P	WASHER
*	25	6	NAS1149F0432P	WASHER
Ì	26	2	NAS1149C0432R	WASHER
ļ	27	4	NAS1149F0563P	WASHER

D4032-041 SHORT BASKET ASSY (350) (MESH SHOWN LOCALLY FOR CLARITY)

Stra K FNCrUNCOMER : SUBJECT :

William

WO 106309 MLJ 13-08-29

REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	JPH	10.03.08
В	ITEM 15 D4086-232 & 16 D4086-243 REMOVED; ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1), QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	мв	10.07.23
E	REFORMAT FOR CLARITY. PICTORIAL UPDATE TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.22

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	9	DRAWING NO. REV.
MFG. APPR.	18	D4032 SHEET 1 OF
APPROVED	149	TITLE SCAL
DE APPR.	-#	SHORT BASKET ASSY (350) NT
DATE 13.0	7.22	THIS DOCUMENT IS PRIVATE AND DOMEDISTRUL AND IS EMPLIED ON THE CHARGES CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OF COMED OR COMMANDANTED TO ANY OTHER PURPOSE OF THE PURPOSE O

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 56 lbs APPROX

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D

С

ITEM	-043 QTY.	P/N	DESCRIPTION
	X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
—	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	6	D3917-3	WASHER
5	2	D3953-3	GAS SPRING STUD, LID
6	2	D3953-7	GAS SPRING SPACER
7	2	D3953-9	GAS SPRING WASHER
8	2	D3953-17	GAS SPRING SPACER
9	1	D3953-19	GAS SPRING BRACKET
10	1	D3953-21	GAS SPRING BRACKET
11	1	D3969-3	SPRING
12	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1	D4019-041	LIGHT LID SHORT BASKET
14	4	AN3-14A	BOLT
15	2	AN3-20A	BOLT
16	3	AN4-12	BOLT
17	2	AN5-17A	BOLT
18	2	AN5-21A	BOLT
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	2	AN310C4	NUT, PLAIN, CASTELLATED
21	6	MS21042L3	NUT, SELF-LOCKING
22	4	MS21042L5	NUT, SELF-LOCKING
23	3	MS24665-151	COTTER PIN
24	2	MS24665-300	COTTER PIN
25	6	NAS1149F0432P	WASHER
26	2	NAS1149C0432R	WASHER
27	8	NAS1149F0332P	WASHER
28	4	NAS1149F0563P	WASHER

D4032-043 SHORT BASKET ASSY, LIGHT LID (350) (MESH SHOWN LOCALLY FOR CLARITY)

106309

DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	a	DRAWING NO. REV. E		
MFG. APPR.	12	D4032 SHEET 2 OF 4		
APPROVED	149	TITLE SCALE		
DE APPR.	d	SHORT BASKET ASSY (350) NTS		
DATE 13.0	7.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOQUMENT IN PRIVATE AND DOMEDRITUM, AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ORDER OR CONVENIENCE TED TO ANY OTHER PERSON WITHOUT		

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 45 lbs APPROX



